



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST4241-13
Job Sheet 199254



Part No: RBST4241-13

Job Qty: 4 pcs

Part Name: Secondary Seat



DAS
21
9-09

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST4241 Rev 1 IPP Rev. A 19.08.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	4 pcs	10/7/19	10/7/19	1.00	1.00	SL-154 - 1	19/09/20
120	QC 2	4 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	19/09/20
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S215511



Part: RBST4241 - 13

Job No: 199254

Serial No/Batch: S215511

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/20/19

8/15/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

130 QC 8	4 pcs	10/7/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Outsource - 12 - Black Oxide	4 pcs	10/7/19		GRO002-VC	10
160 Packaging 2-1 - Receive - B4B	4 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

11/18 19/19/23

2019-09-24

11E OCT 03 2019

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					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	
170 QC 6	4 pcs	10/7/19	0.00	0.00	QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	4 pcs	10/7/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	4 pcs	10/7/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89 OCT 04 2019

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per FOLIO FC AA FOLIO REV: 1 DWG REV:
 Descriptions: 2-Deburr 3-Engrave P/N And / or T/N number as required Using Marktronic engraver as per DWG.
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 150 - -Issue P/O; 44580 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-
 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;
 4140 -Certificate of Conformity is required
 160 - Receive & Inspect for Damage & Mat'l Certs
 170 - QC6- All purchased or subcontracted products

8/15/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 - Identify as per dwg & Stock Location: _____
210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.625	AISI 4140 Quenched & Tempered Steel Round Bar 1.625" Dia.	.3680 ft (.092 ea)	110-SL-154 - 1	5172299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-4140QT-R1.625	0	26	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	199254
Description: SECONDARY SEAT		Part Number:	RBST 4241-13
Inspection Dwg:	RBST 4241-13	Rev:	1
			Page 1 of 1

INSPECTION SHEET

[illegible]

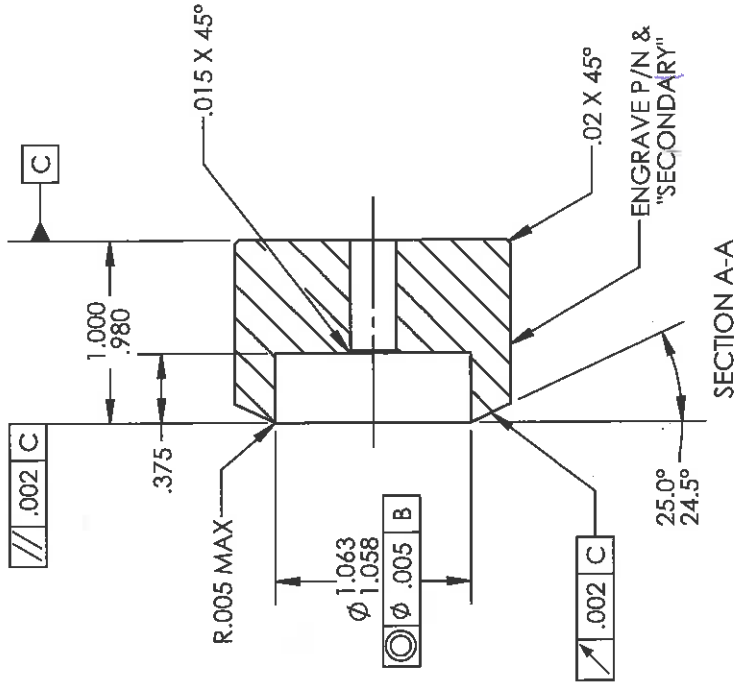
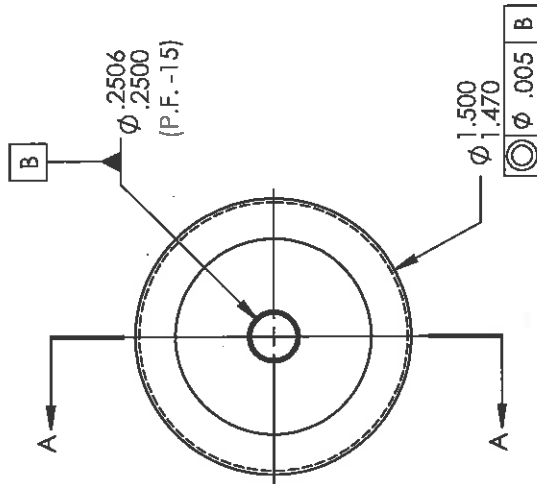
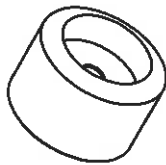
Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS			
REV	ECR	DESCRIPTION	APPROVED



NOTE:
BREAK ALL SHARP CORNERS .015 - .030.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 199254 NCS
1908-15



TITLE
DRILL PRESS SWAGING TOOL

DWG NO.	RBST4241-13	REV	1
MAT'L	4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm 1/16$	
HEAT	RC 28-34	.XXX $\pm .005$	
FINISH	BLACK OXIDE	.XX $\pm .01$	
SPEC	QMSI-6.2.2, B.O. REV D	.X $\pm .1$	
DRAWN BY:	DD 04/05/2017	1. BREAK ALL SHARP EDGES SURFACES = 125	
CHECKED:	SM 04/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	AA 04/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	JL 04/05/2017	USED ON MODEL	
APPROVED:	JAG 04/06/2017		
SCALE	1:1	DATE	4/5/2017
		SHEET 8 OF 9	

(-13)

SECONDARY SEAT



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Prod. Eng. Coord. ☐ Water Jet ☐
Large Fab ☐ Rec/Store/Packaging ☐ Supplier ☐
Finishing ☐ Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044580



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044580
PO Date: 9/24/19
Due Date: 10/2/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2019-09-25

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199254	RBST4241-13	Secondary Seat -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	XG	10/2/19	6 pcs	0 pcs	6 pcs	\$10.00/pcs	\$60.00
2	199253	RBST4241-11	Primary Seat -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	XG	10/2/19	6 pcs	0 pcs	6 pcs	\$10.00/pcs	\$60.00
Grand Total:										\$120.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER

POHB044580



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/25/19 9:47 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022717-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022717 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
27-Sep-2019		Jigar Patel			POHB044580			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBST4241-13 Rev. ✓	RBST4241-13 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
2	RBST4241-11 Rev. ✓	RBST4241-11 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0

DAS
61
9-89

RECEIVED
OCT 0 1 2019
DART AEROSPACE LTD.

RECEIVED
 OCT 01 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

[Signature]

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.